

Date: Monday, 6/12/2006 2:33:44 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350/212/130 BASKET LID
Job Number : 27520B	
Estimate Number : 10193	
P.O. Number : NIA	Part Number : D2512
This Issue : 6/12/2006 S.O. No. : NIA	Drawing Number : D2512 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : LARGE FAB ASSY	Drawing Revision : D2
Previous Run : 27487A	Material : NIA
Written By : <i>See Comment Below</i>	Due Date : 6/30/2006 Qty: 1 Um: Each
Checked & Approved By : <i>06.06.12</i>	
Comment : Rev Est:M 08.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s) *(12.54) CPL 06.06.13*

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: *m100023* → *51"* *4.25* *m101111* → *467.53* *38.96* *(14.93)*

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3166-3

Basket Hoop

*B27327**cpl 06.06.12*

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

*B26631-2**cpl 06.06.16*

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

*B26742**cpl 06.06.16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 2:33:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27520B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B25238

CPL 06.06.16

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B26204

CPL 06.06.16

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M100999 M100981

CPL 06.06.17

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig D18305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

CPL 06.06.23

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 06/07/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 2:33:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27520B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/30/06 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

spray paint wing walk
Batch: M101032 R101266 FC 06/07/07 ①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-07-05 ①

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/07 ①
U 06/07/07

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

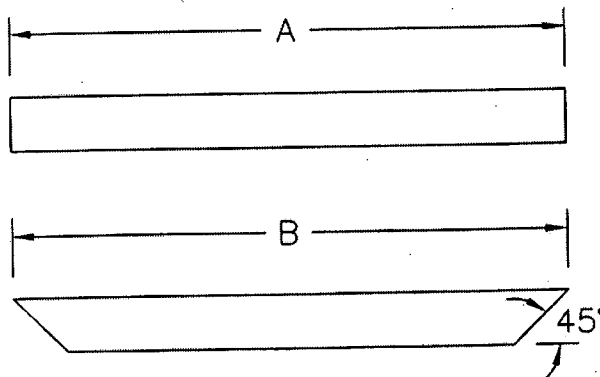


DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) SCALE NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	CP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	CP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27520B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

Copyright © 1995 by DART AEROSPACE LTD

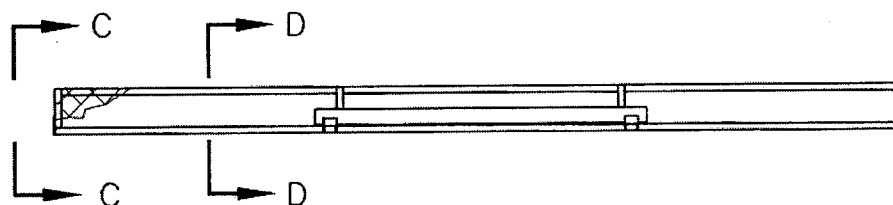
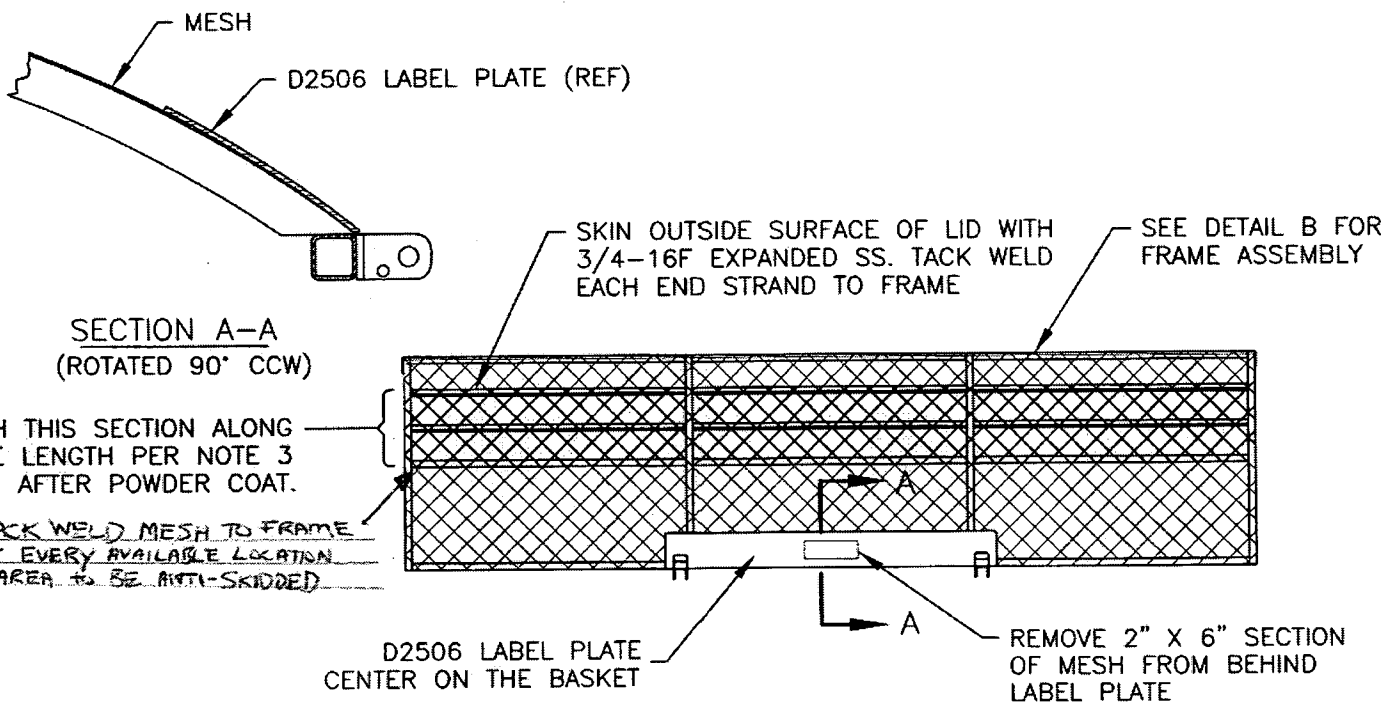
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

1
2
3
4

DART



DESIGN	BW	DRAWN BY	JC	DART AEROSPACE LTD
CHECKED	+	APPROVED	+	HAWKESBURY, ONTARIO, CANADA
DATE	01.04.19	DRAWING NO.	D2512	REV. D
		TITLE	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE	1:20	



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

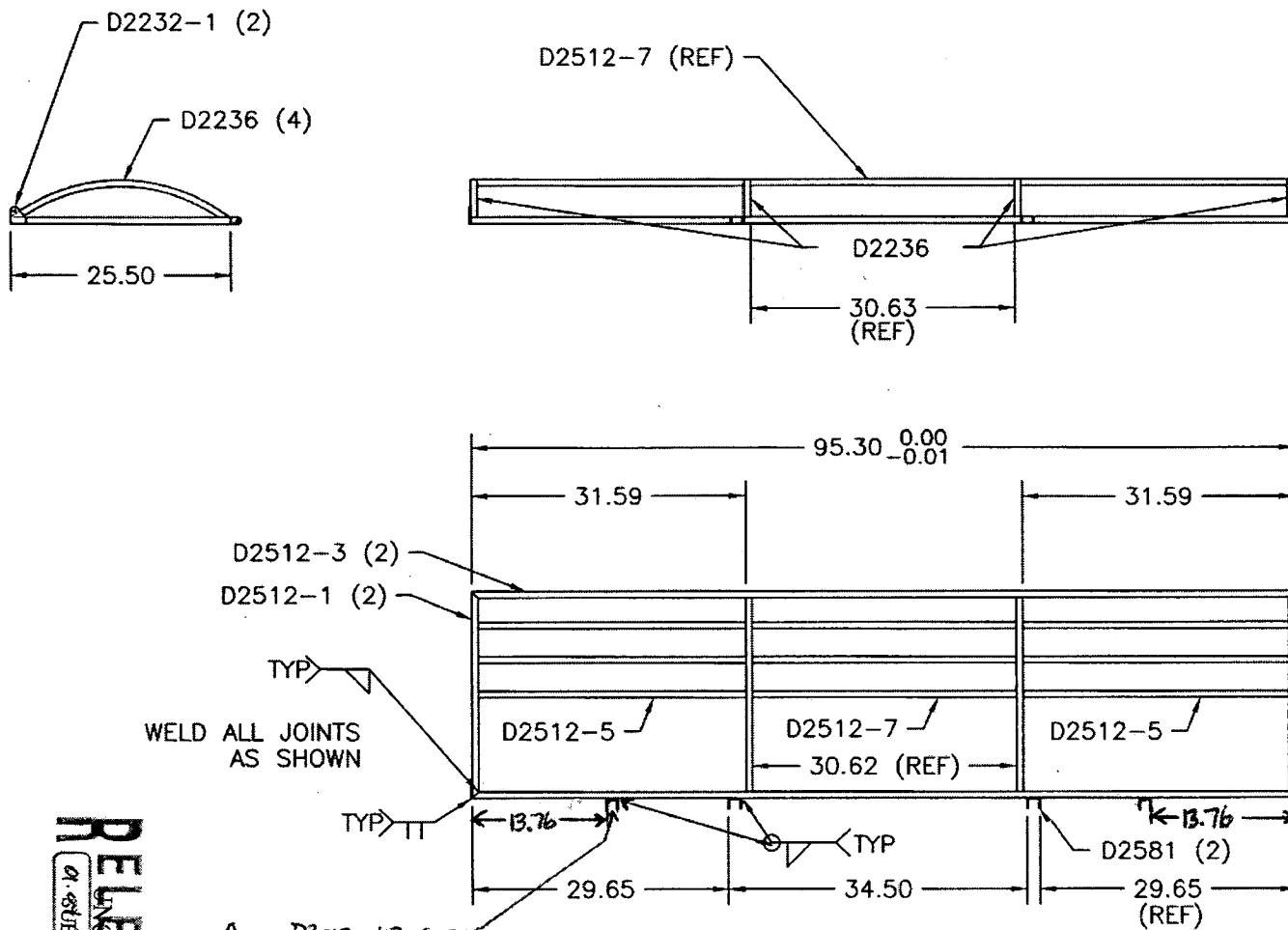


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO
RELEASE
WORK ORDER
NO. 27520 B

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
BW	UP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 4
01.04.19		D2512	SCALE
		TITLE	
		BASKET LID ASSEMBLY (350/212)	1:20



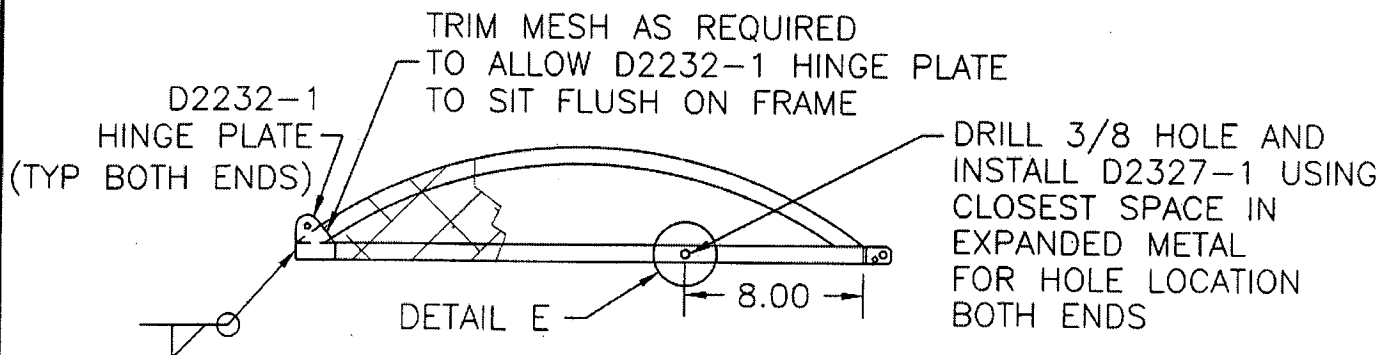
DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D2012-117 CLEMS
ADD FOR D130-701-041
ONLY (2 PLACES)

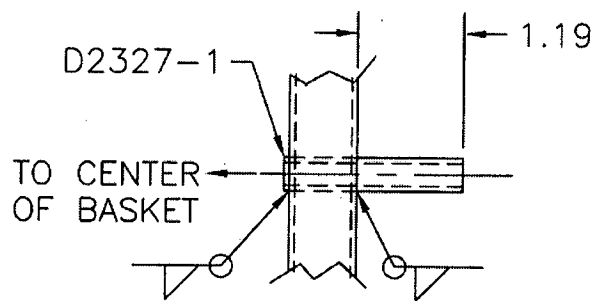
SHOP COPY
RETURN TO
ENGINEERING
DEPT
NO. 215203
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
RELEASED
ON REQUESTED COPY
a. SUBJECT TO AMENDMENT



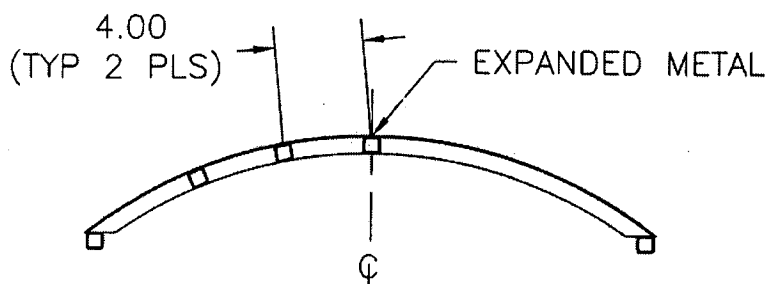
DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

SHOP COPY
RETURN TO
ENGINEERING
RELEASED
UNCONTROLLED COPY
SUBJECT TO ATTENTION
WITHOUT NOTICE
WORK ORDER
NO. 27520B

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.